



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-411BL
Job Sheet 176321



Part No: D206-642-411BL

Job Qty: 1 ea

Part Name: Skidtube LH, High Gear- Air Evac Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/20/18

Job Tracking No:

Due Date: 4/25/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV Q SHEETS 31-32 IPP Rev:A 11.03.22 added route seq DD ver:EC IPP REV:B 14.04.25 AS PER ECN14-520 DD VERF:JLM IPP REV:C 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/25/18	4/25/18	0.00	0.00	Start Up Stores/Pkg-1		APR 23 2018
110	Packaging	1 pcs	4/25/18	4/25/18	0.00	0.00	Packaging1-2		APR 23 2018
120	QC	1 pcs	4/25/18	4/25/18	0.00	0.00	QC4		DAS 58
125	DC	1 pcs	4/25/18	4/25/18	0.00	0.00	DC		9-89
130	Packaging	1 pcs	4/25/18	4/25/18	0.00	0.00	Packaging3-1		APR 26 2018
140	QC21-FG	1 Ea	4/25/18	4/25/18	0.00	0.00	QC21		APR 25 2018

Part Op 125 - Photocopy bluefile and create labels per PPP D206-642-411 CHG008

Descriptions: 130 - Identify and pack for shipping as per PPP D206-642-411 Location: _____ PPP Rev: _____

Container No: S063767
Part: D206-642-411BL
Job No: 176321
Serial No/Batch: S063767
Revision:
Inspector:

Date: 04/23/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

PATENT		S #5735484 / CA #2222184 / EURO #0828655	
P/N	L 706-642-441BL	CHG	CHG005
DESC	Replacement Skidtube	STC	SH98-4
LOT	B131403	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	STC	
TC APPROVAL # 09-89		MADE IN CANADA	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	S038750 S044186
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	S097407
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	S003727
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	S003926
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM134931
AN5-13A	Bolt	4 Ea (4 ea)	90-Start up Operation	
D206-642-441BL	Replacement Skidtube,High Gear with Standard Wearplates Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	S039776 \$631 463
D206-648-013BL	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	S047777 S0 37980
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	S059551 S0 43981
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	S04487 S039 551
D2932-1BL	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	S016626 S0 14877
D2933-1BL	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	S054584 S016 626
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	S054582 S039 580
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	S055048 S039 82
D2938-1BL	Saddle LH Out, 206	1 Ea (1 ea)	90-Start up Operation	S016548 S013418
D2939-1BL	Saddle LH In, 206	1 Ea (1 ea)	90-Start up Operation	S013079 S016548
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	S044985 S039 79
D3413-1 BL	O-Ring	1 Ea (1 ea)	90-Start up Operation	S020324 S0498 55
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	S050328
D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation	S038433
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	S044701 S037641
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	S038086 S015901
MS21043-4	Nut	1 Ea (1 ea)	90-Start up Operation	S039886
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	S028057 S091 381
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	S015269
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	S045845
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	S039036

2702

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	235	0
	AN4-6A	12	1,430	0
	AN4C5A	1	114	0
	AN5-11A	8	197	0
	AN5-12A	4	396	0
	AN5-13A	4	76	0
	<i>pull from stk</i> D206-642-441BL <i>Blue</i>	1	1	0
	D206-648-013BL	1	1	0
	D2652	16	871	0
	D2712	10	839	0
	D2932-1BL <i>Blue</i>	1	3	0
	D2933-1BL <i>Blue</i>	1	3	0
	D2934	2	76	0
	D2935	2	56	0
	D2938-1BL <i>Blue</i>	1	3	0
	D2939-1BL <i>Blue</i>	1	3	0
	D3407-043 <i>Blue</i>	1	25	0
	D3413-1 <i>Blue</i>	1	36	0
	D3456-1	1	115	0
	D3457-1	2	33	0
	MS21042L3	8	2,792	0
	MS21042L4	12	3,587	0
	MS21043-4	1	1,199	0
	NAS1149C0463R	1	306	0
	NAS1149D0363J	8	2,597	0
	NAS1149D0463J	24	6,699	0
	NAS1149D0563J	8	1,667	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002702	S063764	AN3-41A	Bolt	s038750	ST347	8
002702	S063763	AN4-6A	Bolt	s044186	ST345	12
002702	S063762	AN4C5A	Bolt	s019407	ST345	1
002702	S063761	AN5-11A	Bolt	s003927	ST338	8
002702	S063760	AN5-12A	Bolt	s003926	ST338	4
002702	FM136931	AN5-13A	Bolt		ST338	4
002702	F131403	D206-642-441BL	Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH		FG083	1
002702	S039986	D206-648-013BL	Ground Handling Wheel Modification	S039844	ST636	1
002702	S063758	D2652	Bushing	s043981	ST009	16
002702	S063757	D2712	Set Screw	s059551	ST012A	10
002702	S063756	D2932-1BL	Saddle LH Out, 206	s014897	ST389	1
002702	S063755	D2933-1BL	Saddle LH In, 206	s016626	ST390	1
002702	S063753	D2934	Saddle Spacer	s054584	ST014	2
002702	S063752	D2935	Saddle Spacer	s054582	ST014	2
002702	S063751	D2938-1BL	Saddle LH Out, 206	s015248	ST391	1
002702	S063750	D2939-1BL	Saddle LH In, 206	s016548	ST392	1
002702	S063748	D3407-043BL	Tow Ring, Blue Prime/Paint	s013079	ST530	1
002702	S063747	D3413-1BL	O-Ring	s049855	ST530	1
002702	S063746	D3456-1	Washer	s050328	ST036	1
002702	S063745	D3457-1	Washer	s035433	ST036	2
002702	S063744	MS21042L3	Nut	s038764	ST303	8
002702	S063743	MS21042L4	Nut	s045901	ST303	12
002702	S063742	MS21043-4	Nut	s038086	ST302	1
002702	S063741	NAS1149C0463R	Washer	s019381	ST266	1
002702	S063740	NAS1149D0363J	Washer	s015269	ST263	8
002702	S063738	NAS1149D0463J	Washer	s045845	ST263	24
002702	S063737	NAS1149D0563J	Washer	s039036	ST263	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/23/18 7:30 AM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D206-642-411 /-411BL/-412/-412BL

Description: SKIDTUBE , LH/RH[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

ITEM	QTY -411	QTY -412	QTY -413	QTY -414	QTY -441	QTY -457	QTY -449	QTY -451	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-411	SKIDTUBE INSTALLATION, LH
		X								D206-642-412	SKIDTUBE INSTALLATION, RH
			X							D206-642-413	SKIDTUBE INSTALLATION, LH
				X						D206-642-414	SKIDTUBE INSTALLATION, RH
1	1				X					D206-642-441	SKIDTUBE
						X				D206-642-457	WEARSHOE KIT (REPLACES -447)
							X			D206-642-449	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-451	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-7	SKIDTUBE ASSEMBLY
1								1		D4361-043	SKIDTUBE ASSEMBLY
2A					22			10		D2651-1	* PLUG ⁽¹⁾
2B					22			10		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD518)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-15	WEARSHOE (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-37	WEARSHOE (REPLACES D3535-37 + D3536-37)
26A					60	60				MS27039C1-08	SCREW
26B					60	60				NAS1149D0332J	WASHER (OR AN960JD10L)
26C					60					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	LUG ASSEMBLY (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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